

Date: Thursday, 12/13/2007 2:39:21 PM
 User: Kim Johnston

Process Sheet

4

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BEARPAW KIT (19"X24")
 Job Number : 36333
 Estimate Number : 12617
 P.O. Number : N/A Part Number : D315670011
 This Issue : 12/13/2007 S.O. No. : N/A Drawing Number : D2432 REV F3
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : F3
 Previous Run : 36246 Material : N/A
 Due Date : 1/20/2008 Qty: 2 Um: Each
 Written By :
 Checked & Approved By : JLM 07.12.13
 Comment : Est Rev: A New Issue 07-01-03 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



KS 07.12.20

Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D315-670-011 CHG001

08/01/13

2.0 MUHMWB10 UHMW 1" Black



Comment: Qty.: 6.8250 sf(s)/Unit Total : 13.6500 sf(s)
 blank: 19.500" x 24.00" x 1.00" thick (+0.030/-0.000) per DSK086-5
 Material: Black UHMW 1"
 (MUHMWB10)
 Batch: M106717x8 Feet

J.L 08/01/13

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Note: (2) bearpaws for (1) Kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio and Dwg D2432 Identify as D2432F

3-Deburr

J.L 08/01/13

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 08/01/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 12/13/2007 2:39:21 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (19"X24")

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Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 08/01/17

(24)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

7.0

D2182B

Neoprene Cushion-.750 bl



Comment: Qty.: 2.5000 f(s)/Unit Total : 5.0000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2182B050

Rubber Cushion

134777

SP

8.0

D2274

Radius Block



Comment: Qty.: 12.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 D2274

Radius Block

132857 (12x)

130578 (12x)

2 D2432F(ref only)

Bearpaw

SP

9.0

D2438

Clamp



Comment: Qty.: 6.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2438

Clamp

132016 (6x)

130381 (6x)

SP

10.0

D2529

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 D2529

Washer

130382 (12x)

135356 (12x)

8/1/15 SP

(2x)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 08/01/16
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 12/13/2007 2:39:21 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (19"X24")

Job Number: 36333

Part Number: D315670011

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

AN417A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN4-17A

Bolt

M103691

SP

12.0

AN960JD416

Washer



Comment: Qty.: 24.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

24 AN960JD416

Washer

M105906

SP

13.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 MS21042L4

Nut (or -4)

M105054

8/1/15

SP (2x)

14.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

08/01/15 (2x)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPPD315-670-011

Location: A

8/1/15 SP (2x)

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/01/16

Job Completion



2008/11/16

W

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	<u>36333</u>
Description: Bearpaw		Part Number:	D2432
Inspection Dwg: D2432	Rev: F3	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.061 x 45°	✓			
B	5.500	+/-0.030	5.500	✓			
C	0.200	+/-0.030	.198	✓			
D	0.25 x 45°	+/-0.030	.245 x 45°	✓			
E	R0.250	+/-0.030	.250	✓			
F	0.250	+/-0.010	.255	✓			
G	0.625	+/-0.030	.620	✓			
H	0.375	+/-0.010	.377	✓			
I	0.950	+0.030/0.010	.953	✓			
J	19.000	+/-0.030	19.00	✓			
K	3.14	+/-0.030	3.14	✓			
L	3.28	+/-0.030	3.28	✓			
M	Ø0.260	+0.005/-0.000	.260	✓			
N	Ø0.93	+/-0.030	.930	✓			
O	0.30	+0.030/-0.000	.315	✓			
P	23.750	+/-0.030	23.75	✓			
Q	7.375	+/-0.030	7.375	✓			
R	4.250	+/-0.010	4.250	✓			
S	2.000	+/-0.030	2.010	✓			
T	9.000	+/-0.010	9.002	✓			
U	9.000	+/-0.010	9.001	✓			
V	0.375	+/-0.010	.376	✓			

Measured by:	<u>SL</u>	Audited by:	<u>SD</u>	Prototype Approval:	N/A
Date:	<u>08/01/13</u>	Date:	<u>08/01/14</u>	Date:	

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	P/O K10008/D206-559-015	KJ/RF <u>RF</u>

F1	99.03.03	ADD DEO 9143
F2	01.03.28	Ø0.93 WAS Ø0.75 RF
F3	02.01.23	CLARIFY BORE DIMS RF

RELEASED
98.06.17 KE

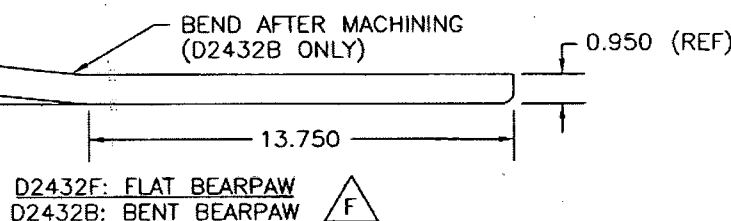
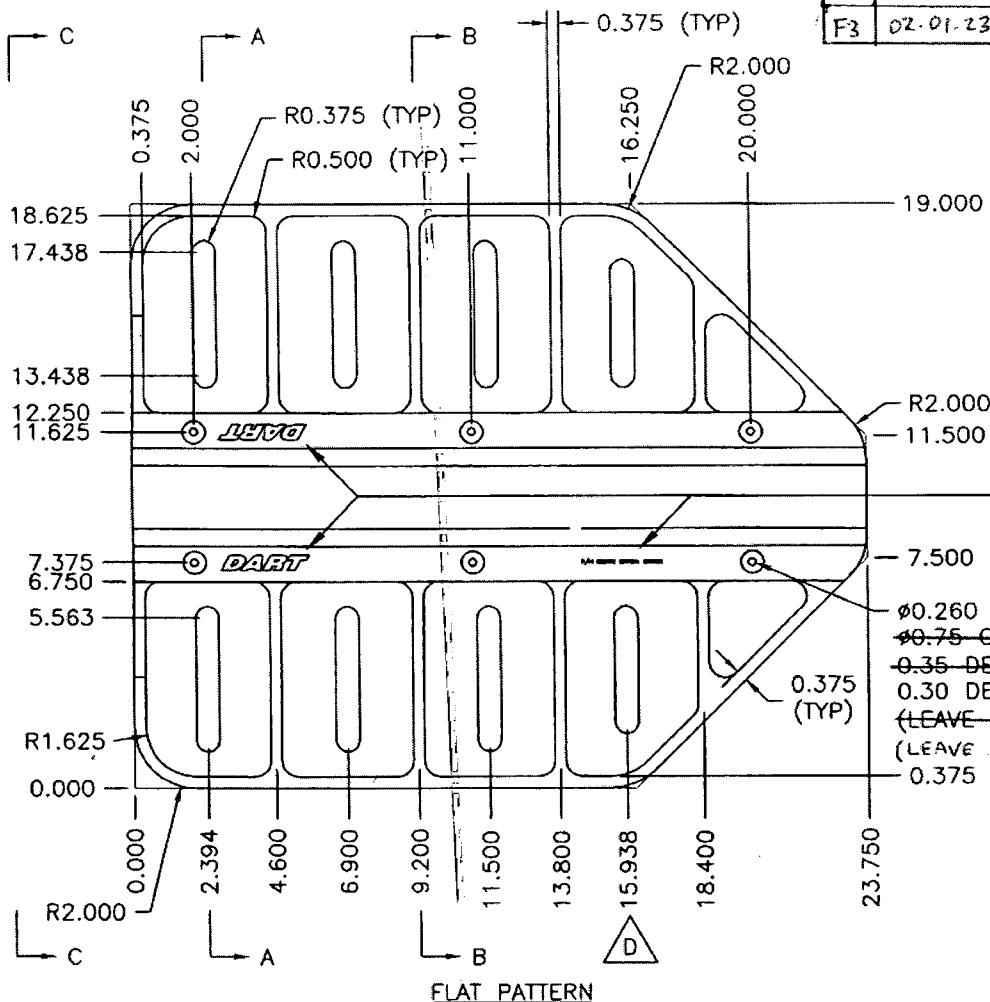
DART



ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
KE	KE	
CHECKED	APPROVED	DRAWING NO.
MM	KE	D2432
DATE	TITLE	REV. F
98.05.12	BEARPAW	SHEET 1 OF 2
		SCALE 1:6
A	95.10.31	NEW ISSUE
B	96.01.24	RE-DESIGN
C	96.03.26	CHANGE BORE AND C'BORE DEPTH
D	96.06.04	MOVE SLOT
E	97.02.27	CHANGE C'BORE DEPTH, BORE RADIUS
F	98.05.12	CHANGE C'BORE, ADD B AND F P/N

EFFECTIVE	DEOS
9143	



MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

NO. 36333
WORK ORDER
SUBJECT TO AMENDMENT
WITHOUT NOTICE
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY
36333



DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED ME	APPROVED [Signature]	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12		TITLE BEARPAW	SCALE 1:4

RELEASED
98.06.17 KE

